

Work Order ID 80990***80990***

Page 1

March-06-12 9:17:38 AM

Item ID: D2661-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 06/03/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/03/06 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program part number and batch number MACHINE AS PER DWG AND FOLIO FB071 FOLIO REV: <u>AA</u> DWG REV: <u>E</u>								
110	CONVENTIONAL MILLING MACHINE	0.00							
110									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80990

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Page 2

Item ID: D2661-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH Fwd Aft Out 206
 Start Date: 06/03/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 20/03/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>F.K / 12/07/06</i>		<i>22</i>	<i>28</i>		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>OK 12/07/08</i>		<i>22</i>	<i>10</i>		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>22</i>	<i>76</i>	<i>12-29</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80990

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Item ID: D2661-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop

NS2

Start Date: 06/03/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

22X ϕ 12/07/09

22 ϕ 12/7/9

22 ϕ 12-7-10 SP

M121841

10:30

3200 F

11:00

434

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80990***80990***

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March-06-12 9:17:38 AM

Item ID: D2661-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop ***NS2***

Start Date: 06/03/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

OK 12/7/11

MF
12-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 9:17:41 AM

Page 1

Work Order ID: 80990

80990

Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	47.0000	1	20			

D6101-003

**

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	28	
73775	2	
73780	7	
78159	2	
78599	10	
MAT041	25	
79587	25	
MAT042	-7	
MAT044	1	
73769	1	

81924

85434

10

12

F.K 12/07/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	80996
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.614	3.614	3.615	3.615
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.317	.317	.317	.317	.317
D	2.495	2.505		2.500	2.500	2.499	2.502	2.502
E	1.674	1.684		1.679	1.683	1.682	1.683	1.681
F	1.357	1.367		1.362	1.363	1.3625	1.362	1.363
G	0.100	0.140		.124	.118	.117	.117	.113
H	0.210	0.230		.227	.225	.220	.221	.221
I	0.615	0.685		.680	.667	.680	.680	.680
J	2.470	2.510		2.492	2.492	2.493	2.492	2.492
K	1.313	1.343		1.326	1.323	1.323	1.323	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.137	1.130	1.130	1.130	1.127
O	0.100	0.180		.135	.140	.140	.140	.140
P	0.100	0.140		.115	.126	.122	.116	.119
Q	0.240	0.260		.250	.252	.251	.252	.250
R	0.677	0.697		.687	.691	.691	.690	.691
S	0.100	0.140		.122	.128	.128	.125	.127
T	1.565	1.585		1.577	1.570	1.570	1.570	1.567
U	0.540	0.560		.550	.547	.546	.547	.545
V	0.912	0.932		.923	.928	.929	.927	.928
W	0.787	0.807		.797	.796	.798	.795	.794
X	5.990	6.010		6.000	6.001	6.001	6.001	6.001
Y	4.995	5.005		5.000	4.999	4.997	4.999	4.999
Z	0.490	0.510		.500	.502	.504	.5005	.504
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.001	1.001	1.001	1.001
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510	.500	3.745	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.749	3.749	3.749	3.749
AF	0.235	0.240		.237	236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.111	.111	.111	.111
AI								

DART AEROSPACE LTD		Work Order:	80990
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: <i>J. F. F.</i>	Date: 12/07/05
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Audited by: <i>CM</i>	Date: 12/07/08
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Prototype Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	80996
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
A	3.611	3.621	3.614	3.614	3.615	3.614	3.615	3.613
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.317	.317	.317	.317	.317
D	2.495	2.505		2.501	2.499	2.501	2.5015	2.502
E	1.674	1.684		1.681	1.680	1.679	1.6815	1.681
F	1.357	1.367		1.361	1.363	1.3615	1.363	1.362
G	0.100	0.140		.111	.109	.107	.109	.115
H	0.210	0.230		.220	.217	.217	.218	.219
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.492	2.492	2.492	2.492	2.492
K	1.313	1.343		1.323	1.323	1.323	1.323	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1317	1.129	1.128	1.1316	1.1327
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.115	.122	.118	.115	.116
Q	0.240	0.260		.251	.253	.254	.252	.250
R	0.677	0.697		.691	.691	.690	.691	.691
S	0.100	0.140		.125	.124	.124	.123	.123
T	1.565	1.585		1.5722	1.5695	1.568	1.5714	1.5735
U	0.540	0.560		.545	.545	.545	.547	.546
V	0.912	0.932		.921	.928	.929	.927	.928
W	0.787	0.807		.795	.796	.795	.797	.794
X	5.990	6.010		6.001	6.000	6.000	6.000	6.000
Y	4.995	5.005		4.999	5.000	5.000	5.000	5.000
Z	0.490	0.510		.503	.502	.5025	.5005	.5005
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.001	1.001	1.001	1.001	1.001
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.111	.111	.111	.111	.111
AI								

DART AEROSPACE LTD		Work Order:	80990
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: *JS / E.E.* **Date:** 12/07/06

Audited by: *CDK* **Date:** 12/07/08

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	80996
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661	Rev: E	DSK:	Rev:
			Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11 X	12 X	13 X	14 X	15 X
A	3.611	3.621		3.615	3.614	3.6135	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.317	.317	.317	.317	.317
D	2.495	2.505		2.502	2.500	2.499	2.501	2.500
E	1.674	1.684		1.681	1.679	1.681	1.679	1.679
F	1.357	1.367		1.363	1.362	1.363	1.362	1.362
G	0.100	0.140		.115	.124	.119	.120	.120
H	0.210	0.230		.218	.220	.215	.218	.218
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.323	1.323	1.323	1.323	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.135	1.144	1.141	1.141	1.140
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.115	.111	.112	.115	.114
Q	0.240	0.260		.248	.240	.240	.248	.241
R	0.677	0.697		.688	.690	.689	.689	.687
S	0.100	0.140		.123	.118	.118	.118	.118
T	1.565	1.585		1.5762	1.581	1.578	1.581	1.5796
U	0.540	0.560		.5485	.547	.547	.549	.550
V	0.912	0.932		.926	.925	.926	.925	.925
W	0.787	0.807		.797	.796	.798	.796	.795
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.502	.500	.503	.503
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
AI								

DART AEROSPACE LTD		Work Order:	80990
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	12/07/06
Audited by:	<i>[Signature]</i>	Date:	12/07/08
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	80996
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16 \times	17 \times	18 \times	19 \times	20 \times
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.317	.317	.317	.317	.317
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.121	.120	.120	.120	.122
H	0.210	0.230		.218	.218	.220	.217	.217
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.323	1.323	1.324	1.324	1.326
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.140	1.142	1.135	1.136	1.138
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.118	.115	.117	.117	.117
Q	0.240	0.260		.241	.241	.250	.250	.250
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.120	.120	.123	.124	.125
T	1.565	1.585		1.580	1.582	1.5755	1.576	1.578
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.912	0.932		.922	.923	.926	.926	.926
W	0.787	0.807		.796	.796	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.006	5.000	5.000	5.000
Z	0.490	0.510		.502	.502	.503	.503	.503
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
AI								

DART AEROSPACE LTD		Work Order:	80990
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by:	<i>SJ / F.K.</i>	Date:	12/07/07
Audited by:	<i>OMZ</i>	Date:	12/07/08
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

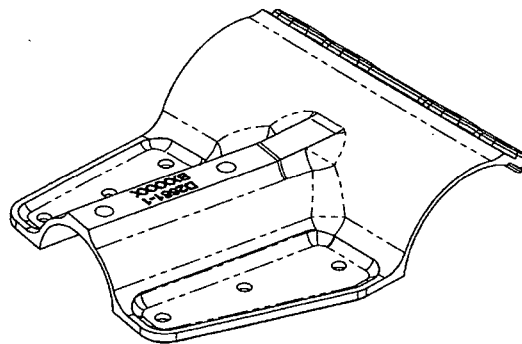
DART AEROSPACE LTD				Work Order: 80990	
Description: 206 Saddle, Outboard, Right side				Part Number: D2661-2	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

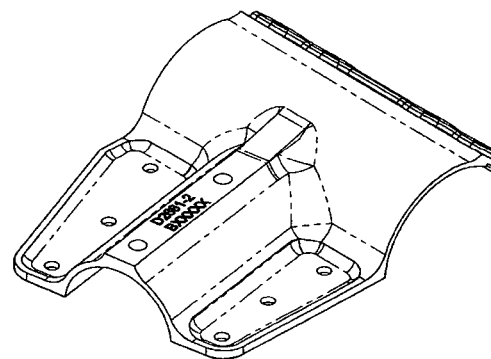
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21 X	22 X	3	4	5
A	3.611	3.621		3.616	3.616			
B	0.256	0.263		.258	.258			
C	0.315	0.322		.317	.317			
D	2.495	2.505		2.500	2.500			
E	1.674	1.684		1.679	1.679			
F	1.357	1.367		1.362	1.362			
G	0.100	0.140		.120	.121			
H	0.210	0.230		.218	.218			
I	0.615	0.685		.680	.680			
J	2.470	2.510		2.490	2.490			
K	1.313	1.343		1.324	1.324			
L	0.178	0.198		.188	.188			
M	0.470	0.530		.500	.500			
N	1.125	1.145		1.136	1.1365			
O	0.100	0.180		.135	.135			
P	0.100	0.140		.117	.116			
Q	0.240	0.260		.250	.247			
R	0.677	0.697		.687	.687			
S	0.100	0.140		.125	.125			
T	1.565	1.585		1.576	1.577			
U	0.540	0.560		.550	.550			
V	0.912	0.932		.924	.924			
W	0.787	0.807		.797	.797			
X	5.990	6.010		6.000	6.000			
Y	4.995	5.005		5.000	5.000			
Z	0.490	0.510		.500	.500			
AA	0.312	0.319		.314	.314			
AB	0.990	1.010		1.001	1.000			
AC	1.245	1.255		1.250	1.250			
AD	0.490	0.510		.502	.502			
AE	3.745	3.755		3.750	3.750			
AF	0.235	0.240		.236	.236			
AG	0.510	0.515		.512	.512			
AH	0.100	0.120		.111	.111			
Accept/Reject								

Measured by: F.K. 12/07/07	Date: 12/07/07
Audited by: 12/07/07	Date: 12/07/08
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

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2011-11-16

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 80990 MLJ
12/03/06

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4). REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.31		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D2661** REV. E
SHEET 1 OF 5
TITLE **SADDLE, OUTSIDE** SCALE **NTS**

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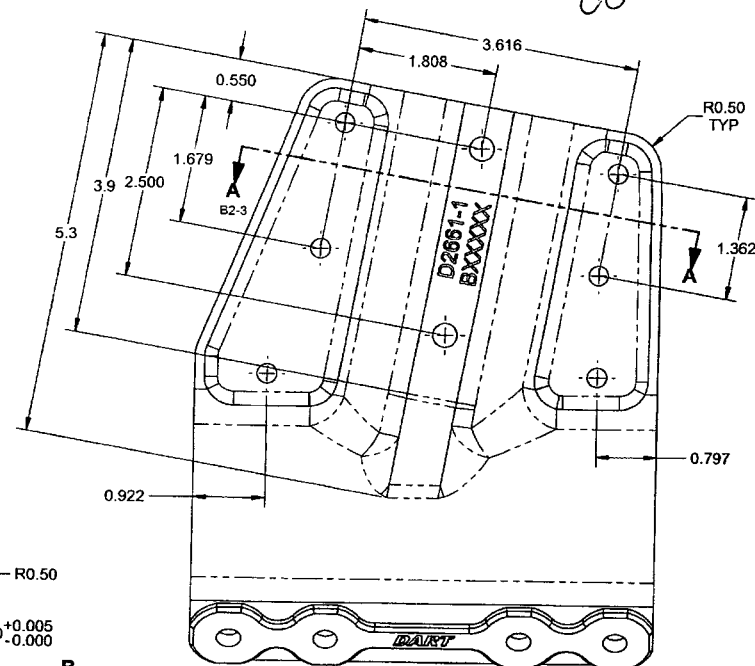
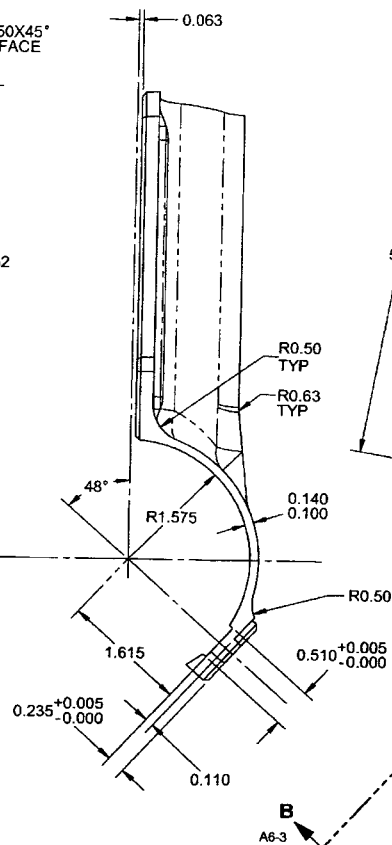
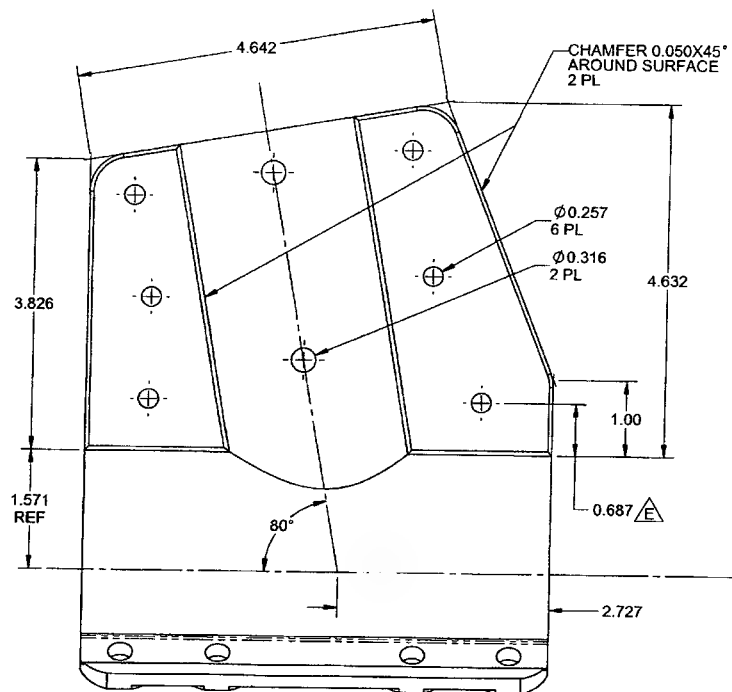
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

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2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	JB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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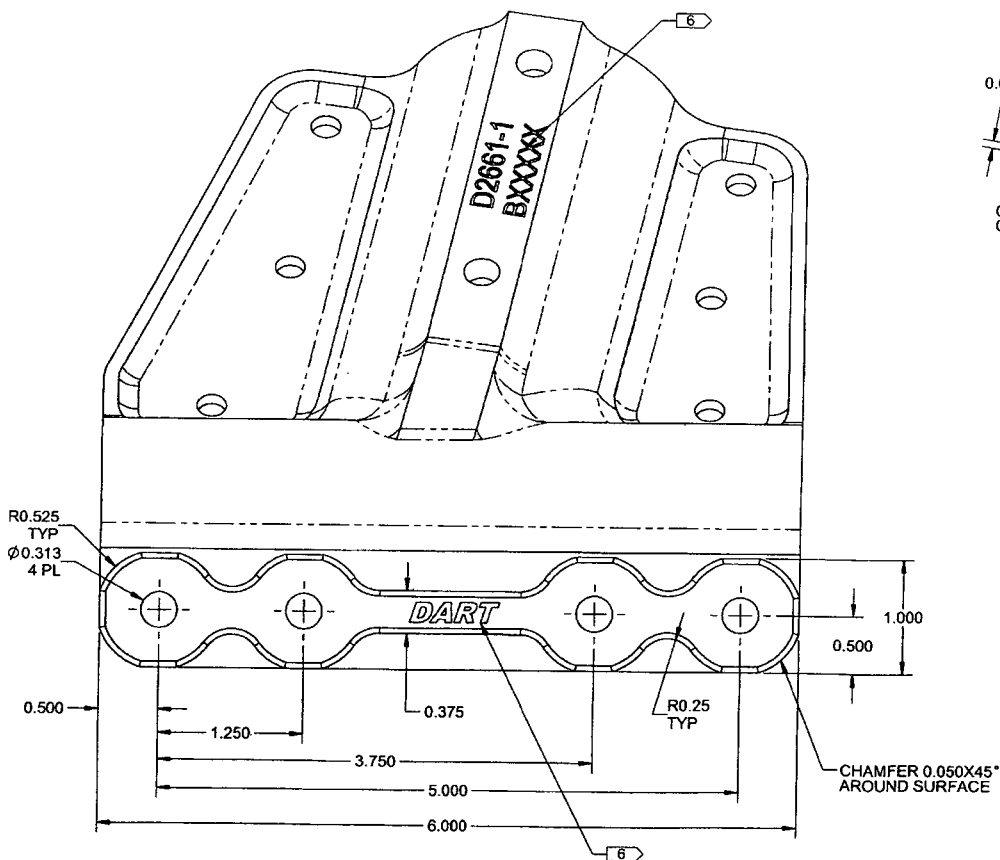
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

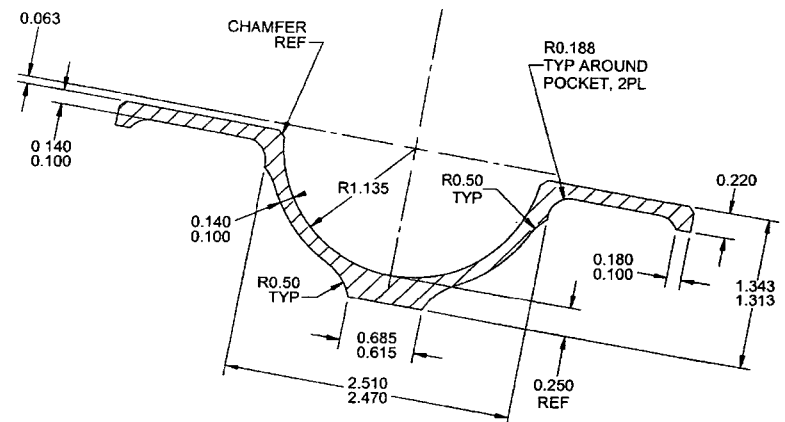
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



VIEW B-B
SCALE 1.5X A4-2
VIEW ROTATED



VIEW A-A
SCALE 1.5X C3-2

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MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SCALE	
DE APPR.		SADDLE, OUTSIDE	
DATE	11.10.31	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

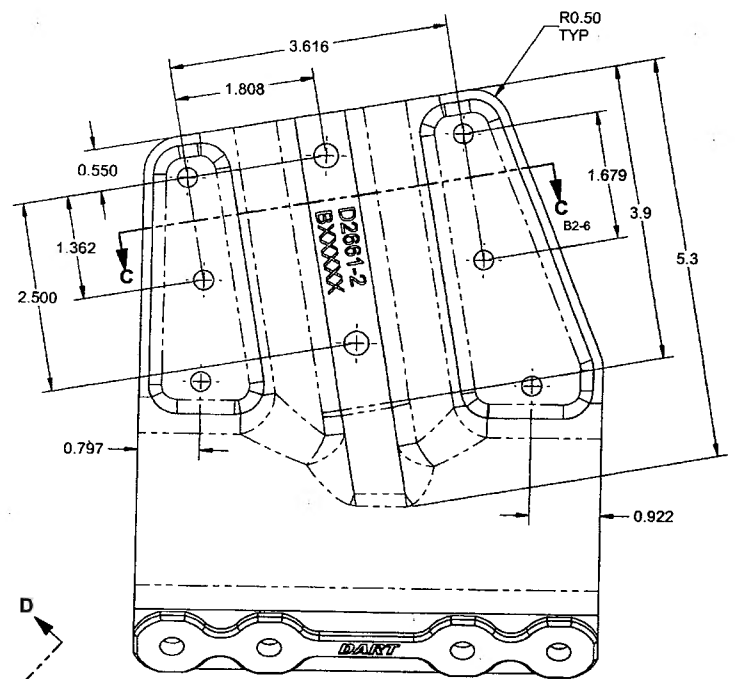
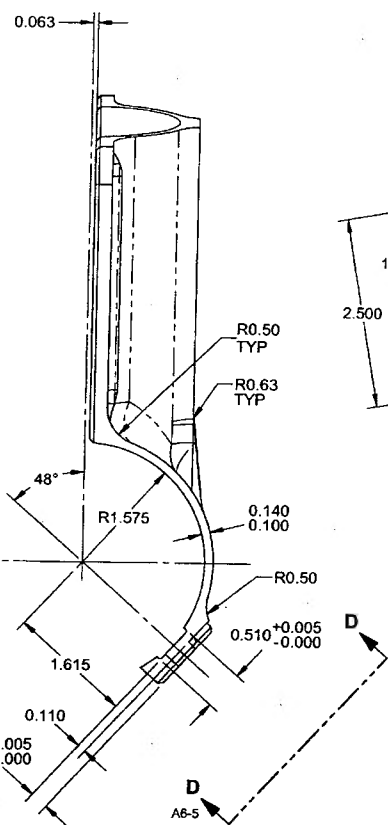
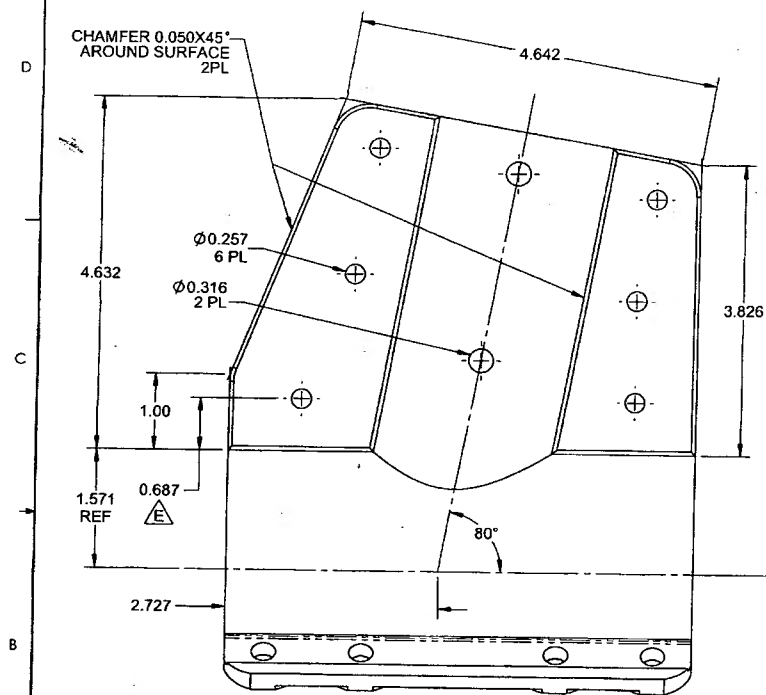
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80990



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2011-11-16

D2661-2 SADDLE, OUTSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

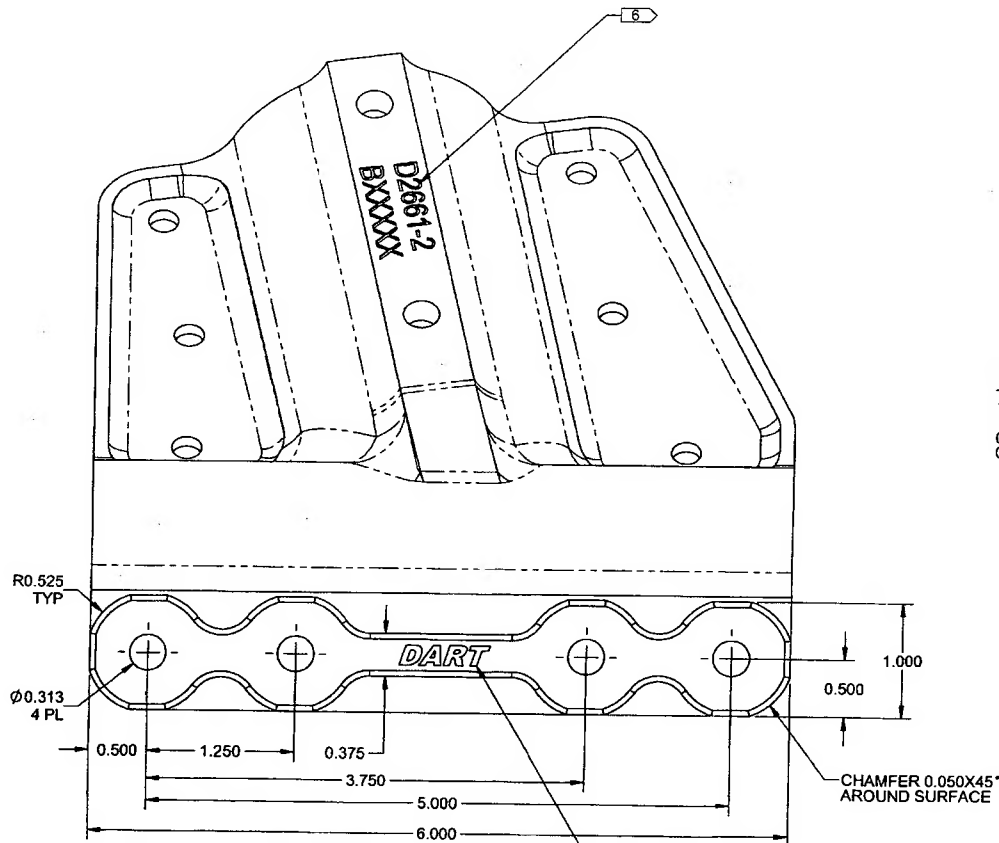
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

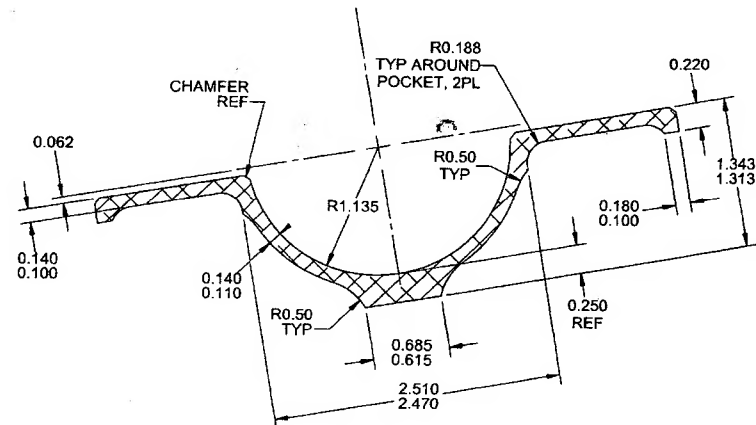
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80990



VIEW D-D 84-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries